	D4030-041				3745*						Page 1
Item ID: Revision ID: Item Name:	Long Basket /	Assembly (350)	/	Accept	*N900	<b>040</b>	100	<b>)*</b> s	etup Star	1.71	S1* S2*
Start Date: Required Date: Reference:	9/16/13	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:				14	
Approvals: Process Plan: QC: Sequence ID/ O		in: MCJ	• •	Tooling: SPC (Y/N):		ate:		R	tun Star Stop		R1* R2*
Sequence ID/ Work Center II	<b>D</b>	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	ision Nbr									<del>-</del>
D4030	D										
*100 *100* Packaging Packaging		Pick Kit Memo		0.00							DAS 33 9-89-13-10-2
*110 *110*		Assemble as per dwg		0.00				١. ٥	ſ	οlΛ	13/10/36
HandFinish Hand Finishing		Memo  ****Mask land area fo	abel plate to size of D4086 l. r label, apply label ****	0.00 abel, use scotchbrite re	d pad to lightly				· ——(—	_94_	13/01 )6
*120 *120*		QC5- Inspect part compl	leteness to step on W/O	0.00							<b>195</b> 13:10-31

Quality Control

												DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORN	/ANCE / UP	DATE					
						<u> </u>		_			QA C	losed:	Da	te:	
Work Orde	er.					DISPOSITION				AGAINST D	EPART	MENT	/PROCESS		
Part N	use Date Step Qty					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	Re		Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Quality Other
Root					Descri	otion of work order update		Initial	Ac	tion	Sig	n &			
Cause		Date	Step	Qty	c	or Non-conformance	Ch	nief Eng	Desc	ription	Da	ate	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
				<del> </del>			AUI	LT CATE	GORY						
Landi		g Gear  Bending  Centre Not Concentric to O/S  Cracks  Crushed/Crimped  Cuffs  Heat Treat  Inspection Strip in Tube				General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instructi Mainte Mislabe Misread	on Incomplete ions Incomplete/ nance led	Unclear	Part II Part L Part N Positi		issing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Ripples in	Bend			Drill Holes	1	Offset							

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord				*106	3745*						Page 2
Item ID:	D4030-041	<u> </u>		Accept	*N9000	101C	<b>\</b> 0*	Setup	Start	*N1	C1*
Revision ID:					NACHAR	41711	N I	•		1.71	I
Item Name:	Long Baske	t Assembly (350)							Stop	*N	S2*
Start Date:	9/16/13	Start Qty: 1.00	*1*		Cust Item ID:						
Required Date	e: 9/16/13	<b>Req'd Qty:</b> 1.00	*1*		Customer:						
Reference:			•								
Approvals:	Process P	lan:	Date:	_ Tooling:	Date:		_	Run	Start	*N	R1*
-,-	QC:		Date:	_ SPC (Y/N):	Date:				Stop	*N	R2*
Sequence ID/ Work Center	ID	Operation Description		Set Up/ Run Hours	Tool ID T	ool # Pla Coo		pt Re Qt		Reject Number	Insp. Stamp
130		Identify as per dwg & St	ock Location:	0.00					1	1	
*130* Packaging Packaging		Memo		0.00	RDP 164	178			الكا	4	DAS 6 9-69
140 * 1 4 0 * QC Quality Control		QC21- Final Inspection  Memo	- Work Order Release	0.00					/pe	13-	- 11-04

MB-11-01

										DQA:	Date	e:	
NCR: Y	es / No				WORK ORDER NON	-COI	NFORM	MANCE / UP	DATE	QA Closed:	Date	a·	•
	<del></del>				DISPOSITION				AGAINST D	EPARTMENT			1
Work Orde	r:				1	_, l		. —	_	<b>¬</b>	_		
Part N	lo				Rework Scrap Use-as-is		ľ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	-	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other	
NCR N	lo				Work Order Update			Large Fab	Composite		Supplier		
Root				Descr	iption of work order update	T i	nitial	Ac	ction	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector	
Ooc/Data  quip/Tooling Operator Material Setup Other Process Supplier Fraining Unapproved					•								
1			11			FAUL	T CATE	GORY		·	1		•
Landir	ng Gear				General		·						•
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/ nance led	/Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned V Power Loss/	ct issing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other	-
	Turning			'   <del>-</del>	Finish	$\vdash$		Seguence					

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

## **Picklist Print**

September-11-13 11:35:19 AM

Work Order ID:

106745

Parent Item:

D4030-041

Parent Item Name:

Long Basket Assembly (350)

**Start Date:** 9/16/13

Required Date: 9/16/13

Start Qty: 1.00

Required Qty: 1.00

**Comments:** 

IPP Rev:A new issue DD 10.03.23 verified by:EC

verified by:EC IPP Rev:B as per dwg revB DD

10.04.20 verified by:EC IPP Rev:C as per dwg revC DD 10.08.18 verified by:EC IPP Rev D 12.03.27 per NCR12-1239 EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued <b>DAS</b>	Date Issued	Status
D4086-200 Placard, Max Load		Manufactured	No				Each	15.0000	Сж. м-г	1	<b>33</b> 9-89		
				Location		Loc Qty	<u>L</u>	oc Code					
				ST093		15							
				100	)556	1							
				105	5131	10			10	5131			
				886		1			**				
				962		1							
				985	519	2							
D2530		Manufactured	No			100	Each	12.0000	1	7144	DAS		
Handle Weldment										9 1144	33	/AV	· · · · · · · · · · · · · · · · · · ·
*				<b>Location</b>		Loc Qty	<u>Le</u>	oc Code			9-89		
				ST255		12							
				103	3407	3							
				105	5285	2							
				921	130	2							
				980	)72	5							
D2535		Manufactured	No			100	Each	144.0000	2	2	•		10
Spring									- Para Andrea	<u></u>	- DAS		13-10-2
				Location		Loc Qty	L	oc Code			33		
				ST011		144	_				9-89	i	
					)552	98							
					2576	46			103	2576			

Page 1

										DQA:	Date	2:
NCR: Y	es / No				WORK ORDER NON-C	CONF	ORN	MANCE / UPI	DATE	QA Closed:	Date	·
Work Orde	er:				DISPOSITION				AGAINST DE			
Part N NCR N	lo				Rework Scrap Use-as-is Work Order Update		N Therm	Skid-tube  Machining noforming  Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Init	tial	Act	ion	Sign &	,	
Cause	Date	Step	Qty	d	or Non-conformance	Chie	f Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator [										'	i	
Material												
Setup		ļ										
Other												
Process												
Supplier												
Training												
Unapproved				<u> </u>						1		
					F	AULT	CATE	GORY				
Landir	ng Gear			_	General				_	1	_	_
1	Bending			ļ	Bend	<b>⊢</b>	rain		<u> </u>	Ovalized	_	Pressure/Forced
	Centre No	ot Conce	ntric to	o/s	BOM/Route	<del></del>	ardwa		_	Over/Under	tolerance	Temperature/Cure
ļ	Cracks				Broken/Damaged	_		on Incomplete		Part Incorred	<b>⊢</b>	Weld
	Crushed/Crimped				Burrs	$\vdash$		ions Incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination	1		nance		Part Moved		
	Heat Treat				Countersink	Шм	islabe	led		Positioned V		
	Inspection Strip in Tube				Cut Too Short	$\vdash$	lisread	l		Power Loss/	Surge	Other
	Ripples in	n Bend		1	Drill Holes		ffset					

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Work Order ID:	106745											
Parent Item:	D4030-041							Start	<b>Date:</b> 9/16/13	F	Required Dat	<b>e</b> : 9/16/13
Parent Item Name:	Long Basket Assem	ibly (350)						Star	t Qty: 1.00		Required Qt	y: 1.00
D2537 Bushing		Manufactured	No	٠		100	Each	142.0000	2	2	DAS 33	
Dusining				Location	n	Loc Qty		Loc Code			9-89	
				ST008	=	38						
				51000	102982	30						
					99011	8						
				ST011		104						
					100454	38						
					103608	24			1004	54		
					103861	40						
					98426	2						
D3913-041		Manufactured	No			100	Each	2.0000	1	1 1	(, )	<u>Mistrol</u>
Long Basket Base Assen	1by, 350								1310	-153	<del>u (                                   </del>	-24131(01
		•		Location	<u>n</u>	Loc Qty		Loc Code				
				FP		1						
					102866	1						•
				GA		1						
					103140	1						
D3914-041		Manufactured	No			100	Each	3.0000	1 0	_1_	- C. \	14 3/16/3
Long Basket Lid Assemb	oly (350)								<u> 19 1 (</u>	2 4 SC	22 (1x)	<u> 194 (31/613</u>
				Locatio	<u>n</u>	Loc Qty		Loc Code				
•				FP		1						
					103388	1						
				GA		2						
					103371	1						
					105853	1						
D3917-3		Manufactured	No			100	Each	235.0000	6	6	DAS	(245.00)
Washer										<del> </del>	33	1340-39
				Locatio	<u>n</u>	Loc Qty		Loc Code			9-89	*
				ST072		235						
					100397	70						
:					102913	4				^		
					103536	41			103	536		
•					104859	120						
0 1 1 12 1	1.25.10 434				Char	Dacket Drint						Page 2

										DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	CON	<b>IFORN</b>	ANCE / UP	DATE	•		
										QA Closed:	Date:	
Work Orde	or.				DISPOSITION	İ			AGAINST DE	PARTMENT	PROCESS	
					Rework	1		Skid-tube	Crosstube	, Dane	Water Jet	Engineering
Part N	10.				Scrap Use-as-is	┨		Machining noforming	Small Fab Finishing		d. Eng. Coor. re/Packaging	Quality Other
NCR N	lo		_	. <del></del>	Work Order Update	]		Large Fab	Composite	Rec/Stol	Supplier	- Other
Root				Descri	ption of work order update	lr	nitial	Act	ion	Sign &		
Cause	Date	Step	Qty	C	or Non-conformance	Chi	ef Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator												
Material											<u> </u>	
Setup												
Other						1						
Process												
Supplier												
Training												
Unapproved												
	••••••				F	AUL'	T CATE	GORY			····	
Landi	ng Gear			_	General					•	_	<b>-</b>
	Bending				Bend	Ш	Grain			Ovalized		Pressure/Forced
	Centre No	Centre Not Concentric to O/S BOM/Route					Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks Broken/Damaged					Ш	Inspecti	on Incomplete		Part Incorred	t	Weld
	Crushed/Crimped Burrs						Instruct	ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs		Contamination		Mainte	nance		Part Moved				
	Heat Trea	at			Countersink		Mislabe	led		Positioned V	Vrong	_
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	I		Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes		Offset					

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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Work Order ID:

106745

Parent Item:

D4030-041

Parent Item Name:

Long Basket Assembly (350)

**Start Date:** 9/16/13

Required Date: 9/16/13

Start Qty: 1.00

Required Qty: 1.00

D3953-3 Gas Spring Stud, Lid	Manufactured	No		100	Each	43.0000	2/06	6 87°0	DAS	
,			<u>Location</u>	Loc Oty		Loc Code			9-89	
			GA	1						
			87592	1						
			ST076	42						
			102196 88494	28 14			/6	2196		
D3953-7	Manufactured	No	88494	100	Each	92.0000	2	2	DAG	
Spring Spacer	Manadala								DAS 33	
1,01			Location	Loc Qtv		Loc Code			9-89	
			ST076	92						
			100414	22						
			102928	24			100	<del>~111</del> ~		
			105465	45			102	5465		
	·		99148	1						
D3953-9	Manufactured	No		100	Each	76.0000	2	2	5.0	a <sup>®</sup> - *
Gas Spring Washer									DAS 33	
			<b>Location</b>	Loc Oty		Loc Code			9-89	
			ST076	76						
			102166	21			10.	· · ·		
			103615	46			105	615		
-			94719	4						
			95127	5						
D3953-17	Manufactured	No		100	Each	22.0000	2	2860		13-10-29
Gas Spring Spacer							-lc	09860 19860	DAS	12-10-0
			Location	Loc Qty		Loc Code			33 9-89	
			ST075	22					-	
,			100353	22						

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-O	ONFOR	MANCE / UP	DATE			
									QA Closed:	Date:	
Work Orde	\ <b>r</b> .				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
WOIK OIGE	:I				Rework	1 <b>I</b>	Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	lo				Scrap	1 1	Machining	Small Fab	Pro	d. Eng. Coor.	Quality
, die i					Use-as-is	Ther	moforming	Finishing	4	re/Packaging	Other
NCR N	lo.				Work Order Update		Large Fab	Composite	1	Supplier	
						<u> </u>			<b>.</b>		
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data						1					
Equip/Tooling							1				
Operator											
Material											
Setup		1									
Other											
Process											
Supplier											
Training											
Unapproved		1							<u> </u>		
	. <del></del>				F.	AULT CAT	EGORY				
Landi	ng Gear			_	General			_	7		1
	Bending				Bend	Grain		<u> </u>	Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to	o/s	BOM/Route	Hardw	are		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspec	tion Incomplete		Part Incorre	ct	Weld
	Crushed/	'Crimped			Burrs	Instruc	ctions Incomplete	/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Maint	enance		Part Moved		
	Heat Tre	at			Countersink	Mislab	eled		Positioned \	Wrong	-
	Inspection	n Strip in	Tube		Cut Too Short	Misrea	nd		Power Loss/	/Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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Work Order ID: Parent Item:	106745 D4030-041					Start I	Date: 9/16/13		Required Date: 9/16/13	
Parent Item Name:	Long Basket Assembly (350)					Start	<b>Qty:</b> 1.00		Required Qty: 1.00	
D3953-19 Gas Spring Bracket	Manufactured	No		100	Each	15.0000	1	1	DAS 33	
			Location	Loc Qty		Loc Code			9-89	
·			ST077 100341	15 15			1003	<u>प</u> (		
D3953-21 Gas Spring Bracket	Manufactured	No		100	Each	15.0000	1	1	DAS 33	—
Gas Spring Diacket			<b>Location</b>	Loc Qty		Loc Code			9-89	
			ST077 100404	15 15			1004	04	DAS	
<b>D3969-3</b> Gas Spring	Manufactured	No		100	Each	53.0000	1	1	33 9-89	
			Location	Loc Oty		Loc Code				
			ST262 100611 99623	53 36 17			996	_ 		
AN3-14A Bolt	Purchased	No	,,,, <u></u>	100	Each	131.0000	4	4	DAS 33	13-10-0
	•		Location	Loc Qty		Loc Code	•		9-89	
			ST351 m125709	30 30						
			ST511 m126192	100 100			126192	<u> </u>		
			ST512 123759	1			10000			· · ·

										DQA:	Date	): 
NCR: Y	es / No				WORK ORDER NON-C	ON	FORN	ANCE / UPI	DATE			
										QA Closed:	Date	2:
Work Orde	or:				DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
WOIK OIGC					Rework	1		Skid-tube	Crosstube	7	Water Jet	Engineering
Part N	lo.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is			oforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo				Work Order Update	]		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	ln	itial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	ef Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data						1						
Equip/Tooling												
Operator												
Material [							İ					
Setup		]				İ						
Other												
Process												
Supplier												
Training												
Unapproved												
					F	AULT	CATE	GORY				
Landir	ng Gear				General						_	
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre No	Centre Not Concentric to O/S BOM/Route					Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		nspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/Crimped				Burrs		nstruct	ions Incomplete/l	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved	_	<u> </u>
	Heat Trea	at			Countersink		Mislabe	led		Positioned \	<b>V</b> rong	
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	l	Γ	Power Loss,	/Surge	Other
	Ripples in	n Bend			Drill Holes	П	Offset	•	<b></b>		<u></u>	

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

Work Order ID:	106745											
Parent Item:	D4030-041							Start I	Date: 9/16/13	Re	quired Date: 9/16	/13
Parent Item Name:	Long Basket Assemb	bly (350)						Start	<b>Qty:</b> 1.00	R	equired Qty: 1.00 DAS	1
AN3-16A Bolt		Purchased	No			100	Each	165.0000	2	2	33 9.89	
				Locatio	<u>n</u>	Loc Qty		Loc Code				
				GA		47						
					117441	47				*		
				ST352		118						
					122407	8						
					M125952	10						
					M126192	100			131	e192		
AN5-17A		Purchased	No		4	100	Each	417.0000	4	4	DAS	
Bolt											33	——————————————————————————————————————
				<u>Locatio</u>	<u>n</u>	Loc Qty		Loc Code			<b>9-8</b> 9	
				GA		36						
					117872	36						
		•		ST337		4		•				
					124215	2						
					124805	2						
				st503		227						
					m126176	227				/31		
				ST514		150			126	176		
•					125388	150						
AN4-12 Bolt		Purchased	No			100	Each	131.0000	3	3	DAS 33	13-10-29
				Locatio	<u>n</u>	Loc Oty		Loc Code			9-89	
i :				ST356		131						
					124805	5				<del></del>		
					m125709	50			101	03		
					m126193	76			136	e19 <u>3</u>		

										DQA:	Date:	
NCR:	es / f	lo			WORK ORDER NON-C	O	<b>VFORM</b>	MANCE / UP	DATE	0.1.61	Date	
										QA Closed:	Date:	
Work Orde	or.				DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	T T			Descri	ption of work order update		nitial	Act	tion	Sign &		
Cause	Da	e Step	Qty	1	or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												
1 a d!		<del> </del>		····· <del>V</del>	· · · · · · · · · · · · · · · · · · ·	AUL	T CATE	GORY				
Landi	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend				General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	on Incomplete ions Incomplete/l nance led	Unclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Torq	on j	Drawing	1	JOut of (	Calibration						

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: 106745 **Start Date: 9/16/13** Required Date: 9/16/13 Parent Item: D4030-041 Start Qty: 1.00 Required Qty: 1.00 Long Basket Assembly (350) Parent Item Name: AN310-4 100 No Each 102.0000 3 Purchased DAS Nut 33 Loc Code Location Loc Qty 9-89 ST342 102 112969 122800 125716 42 M125716 M125752 50 M126400 No 100 Each 140.0000 Purchased DAS 13-10-29 9-89 Loc Code Loc Qty Location ST342 140 122993 38 123831 2 126192 50

M125952

50

	•	DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE			

											QA Closed:	Date	e:
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	ا.oo	4,000				Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	I	nitial	Ad	ction	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling			1										
Operator													
Material													
Setup					:								
Other													
Process							1						
Supplier													
Training													
Unapproved						· · · · · · · · · · · · · · · · · · ·	<u> </u>						
						F	AUL	T CATE	GORY				
Landi	ng (	Sear			_	General	_				-	_	
		Bending				Bend	L	Grain		<u></u>	Ovalized		Pressure/Forced
		Centre No	ot Conce	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	<b>.</b>	Cracks				Broken/Damaged		Inspect	ion Incomplete		Part Incorre	ct _	Weld
		Crushed/	Crimped		ļ	Burrs		Instruct	tions Incomplete,	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved		
		Heat Trea	at		<u> </u>	Countersink		Mislabe	eled		Positioned V	Vrong	_
		Inspection	n Strip in	Tube		Cut Too Short		Misrea	t		Power Loss/	Surge	Other
		Ripples in	Bend		<u> </u>	Drill Holes		Offset					
	L	Torque W	/aves in E	Extrusio	n L	Drawing		Out of	Calibration				
·	Turning Sequence Finish			Out of Sequence									
1	Wave/Twist in Tube				Outside	Dimensions							

Work Order ID:	106745										
Parent Item:	D4030-041						Start D	ate: 9/16/13		Required Date:	9/16/13
Parent Item Name:	Long Basket Assembly (350)						Start (	<b>Qty:</b> 1.00		Required Qty:	1.00
MS21042L3	Purchased	No			100	Each	6,501.0000	6	6	DAS 33	
Nut			Locatio	n	Loc Qty		Loc Code			9-89	
			FP001	<b>=</b>	3						
5			11001	122141	3						
			GA		18						
			0.1	122452	18						
			ST314		325						
Ý				111668	1						
a				117885	32						
				119017	55						
				119075	138						
				123265	43						
				M126036	56						
			ST506		1304						
				123900	905						
				124291	399						
			ST510a		4851						
				M126275	851						
r				M126333	4000			126	<del>33</del> ろ		
MS21042L5	Purchased	No			100	Each	1,095.0000	4	4	DAS	(3)
Nut										33 9-89	13-10-2
	·		Locatio	<u>on</u>	Loc Qty		Loc Code			3-09	
			ST314		114						
				125654	114						
			ST506		i						·
				123900	1						
,			st507		980						
			31207	125535	980			125	535		
					700						

NCR:	Yes	/ No				<b>WORK ORDER NON-</b>	COI	NFORM	ANCE / UP	DATE			
											QA Closed:	Date	:
Work Orde	er:					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS	
Part No				Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			<b>⊣</b>	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
Root					Descri	ption of work order update		Initial	Act	ion	Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data	Ш												
Equip/Tooling	Ш						1						
Operator	Щ			]									
Material	Ш		ļ				ļ						
Setup	Щ												
Other	Ш												
Process	Щ												
Supplier													
Training	Ш												
Unapproved			<u> </u>	L	· <u>···</u>								
					<del> </del>		AUI	LT CATE	GORY			<del></del>	
Landi		l .				General	_	1		_	٦	_	<b>-</b>
	<u> </u>	Bending			.,	Bend	$\vdash$	Grain		_	Ovalized		Pressure/Forced
	_	Centre No	ot Concer	ntric to (	<sup>)/5</sup>  -	BOM/Route	-	Hardwa			Over/Under	<u> </u>	Temperature/Cure
	$\vdash$	Cracks	c ·		<u> </u>	Broken/Damaged	-	-1	on Incomplete		Part Incorre		Weld
	Crushed/Crimped			-	Burrs	-	1	ions Incomplete/L	Inclear	Part Lost/M	ssing	Wrong Stock Pulled	
	⊢	Cuffs			-	Contamination	-	Mainte		_	Part Moved		
	$\vdash$	Heat Trea		T I	 	Countersink	-	Mislabe			Positioned V		٦٠٠٠
		Inspectio		iupe	-	Cut Too Short	-	Misread	l		Power Loss/	Surge	Other
·					Drill Holes	$\vdash$	Offset						
j .	Torque Waves in Extrusion					Drawing	wing Out of Calibration						

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

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Work Order ID:	106745										
Parent Item:	D4030-041						Start I	Date: 9/16/13	3	Required Date: 9/	16/13
Parent Item Name:	Long Basket Assembly (350)						Start	<b>Qty:</b> 1.00		Required Qty: 1.	.00
MS24665-151 Cotter Pin	Purchased	No			100	Each	199.0000	3	3	DAS	
Couci i iii			Locatio	n	Loc Qty		Loc Code			ყ-გე <b>ვ</b> 9-89	
			GA	<del></del>	28					9-09	
÷			0.1	17566	28						
			ST323		171						
				122802	20						
				124859	4				<del></del>		
				125646	147			19	5646		
MS24665-300	Purchased	No			100	Each	159.0000	2	2	DAS 33	
COTTER PIN										9-89	
			Locatio	<u>n</u>	Loc Qty		Loc Code			3-00	
			GA		37						
				118234	37						
			ST299		122						
				124555	122			_12	4555	•	
NAS1149F0432P WASHER	Purchased	No			100	Each	2,180.0000	6	6	DAS 33	
			Locatio	on	Loc Oty		Loc Code			9-89	
i I			ST295	<del></del>	180						
			3 <b>.2</b> /2	122151	2						:
ž.				123522	4						
				123900	6						
				124580	13						
5				124859	15						
1				125268	140						
			ST510a		2000			-10	71 7 21		
$\sigma_{c}=4$				M126221	2000				76221		
NAS1149F0563P	Purchased	No			100	Each	602.0000	4	4	DAS	13-10-29
Washer			Lagatic		LoaOtv		Loc Code			33 9-89	
			Locatio	<u>)11</u>	Loc Qty		Loc Code			<del>3-</del> 03	
			ST295	121250	602			1.	21350	1	
				121350	602				2174 D		

								•				DQA:	D	ate:	
NCR:	Yes	/ No				<b>WORK ORDER NON-</b>	COI	NFORM	/ANCE / UP	DATE		·			
												QA Closed:	D	ate:	
Work Orde	er.					DISPOSITION				AGAINST D	EF	PARTMENT	PROCESS		
Part No.  NCR No.					Rework Scrap Use-as-is Work Order Update	Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing  Large Fab Composite			Prod. Eng. ( Rec/Store/Packa				Engineering Quality Other		
Root					Descri	ption of work order update		Initial	Ac	tion	Ţ	Sign &			
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	on	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved	ooling cor cor cor cor cor cor cor cor cor cor									,					
						F	AUI	LT CATE	GORY						
Landi	ng (	1		·		General		٠	<u> </u>		_				1 .
		Bending Centre No	ot Conce	ntric to	o/s	Bend BOM/Route		Grain Hardwa		-		Ovalized Over/Under			Pressure/Forced Temperature/Cure
	<b></b>	Cracks Crushed/	Crimped			Broken/Damaged Burrs		Instruct	on Incomplete ions Incomplete/	/Unclear	-	Part Incorred Part Lost/Mi			Weld Wrong Stock Pulled
Cuffs Heat Treat			Contamination Countersink	Maintenance Mislabeled				Part Moved Positioned W	Vrong						
			Cut Too Short Drill Holes	Misread Offset				Power Loss/S	Surge		Other				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: 106745 D4030-041 **Start Date: 9/16/13** Required Date: 9/16/13 Parent Item: Start Qty: 1.00 Required Qty: 1.00 Parent Item Name: Long Basket Assembly (350) DAS NAS1149F0332P No 100 Each 9,038.0000 8 Purchased 33 Washer 9-89 Location Loc Qty Loc Code GA 182 122063 182 ST294 158 122063 158 ST295 123352 st510 3695 123900 3695 23900 ST510a 5000 5000 125646 100 7,368.0000 NAS1149C0432R Purchased No Each WASHER 33 Location Loc Qty Loc Code 9-89 ST292 2696 119124 6 121255 32 121825 77 122441 2581 m125807 ST510a 4672 126221

4672

m126221

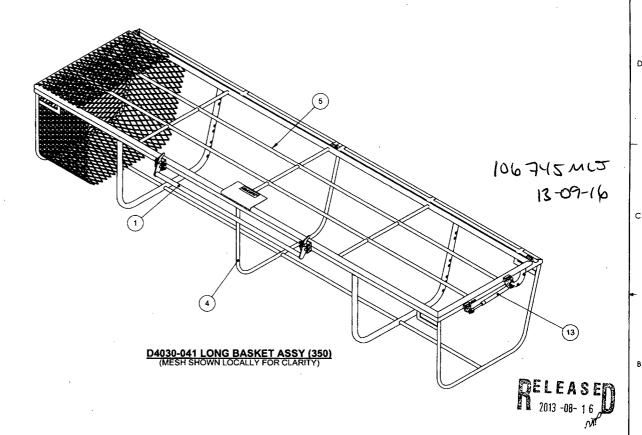
NCR: Y	res /	No			WORK ORDER NON-	CONI	FUKI	VIANCE / UP	DATE	QA Closed:	Da	te:	
					DISPOSITION	T			AGAINST DE	•			
Work Orde	er:					, I			_	1 <i></i>		<del></del> 1	
Part N	ulo.				Rework	┧╽		Skid-tube Machining	Crosstube Small Fab	Dro	Water Jet	<b>—</b>	-
Paiti	NO				Scrap Use-as-is	<b>┤                                    </b>		· —	Finishing	1	d. Eng. Coor.	Qua	`⊢—
NCR N	No				Work Order Update	1	Thermoforming Finishing  Large Fab Composite			<b>—</b>			
Root				Descri	ption of work order update	lni	itial	Ac	tion	Sign &			
Cause	Da	ite Step	Qty	ļ ,	or Non-conformance	Chie	ef Eng	Desc	ription	Date	Verification	n QC Ins	pector
Doc/Data													
Equip/Tooling			1										
Operator						1							
Material						1						İ	
Setup													
Other													
Process						j							
Supplier						1							
Training	Ш	ŀ										ŀ	
Unapproved										<u> </u>			
						AULT	CATE	GORY					
Landi	ng Gear				General					3	1		
	Bend	•			Bend	-	Grain			Ovalized		Pressure/Fo	
	Cent	re Not Conc	entric to	o/s	BOM/Route		lardwa	re		Over/Under	tolerance	Temperatu	re/Cure
	Crac				Broken/Damaged		•	ion Incomplete		Part Incorre		Weld	
		hed/Crimpe	d		Burrs	$\vdash$		ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stoc	k Pulled
	Cuff	S			Contamination	Ш۳	Mainte	enance		Part Moved			
	Heat	Treat			Countersink	Ш,	∕Iislabe	eled	L	Positioned V	Vrong		
	Inspection Strip in Tube				Cut Too Short	_	∕lisread	t		Power Loss/	'Surge	Other	
	<b>—</b> ''	les in Bend		L	Drill Holes	$\vdash$	Offset						
	Torc	jue Waves in	Extrusio	n L	Drawing	Щ	Out of 0	Calibration					
		ing Sequenc		L	Finish	Щ	Out of 9	Sequence					
	Wave/Twist in Tube			Folio		Dutside	Dimensions						

DQA:

Date:

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Ì	ITEM	QTY -041	P/N	DESCRIPTION
	;	х	D4030-041	LONG BASKET ASSY (350)
	1 1	1	D2530	HANDLE WELDMENT
:	1 2	2	D2535	SPRING
	3	2	D2537	BUSHING
D	. 4	1	D3913-041	LONG BASKET BASE ASSY (350)
_	5	1	D3914-041	LONG BASKET LID ASSY (350)
	. 6	6	D3917-3	WASHER
	! 7	2	D3953-3	GAS SPRING STUD, LID
	ł 8	2	D3953-7	GAS SPRING SPACER
	9	2	D3953-9	GAS SPRING WASHER
	10	2	D3953-17	GAS SPRING SPACER
_	1 11	1	D3953-19	GAS SPRING BRACKET
	i 12	1	D3953-21	GAS SPRING BRACKET
.	13	1	D3969-3	SPRING
	; 14	4	AN3-14A	BOLT, MACHINE
	15	2	AN3-16A	BOLT, MACHINE
	116	3	AN4-12	BOLT, MACHINE
	17	4	AN5-17A	BOLT, MACHINE
С	<b>18</b>	2	AN310C4	NUT, PLAIN, CASTELLATED
	19	3	AN310-4	NUT, PLAIN, CASTELLATED
	1 20 .	6	MS21042L3	NUT, SELF-LOCKING
	; 21	4	MS21042L5	NUT, SELF-LOCKING
- 1	1 22	2	MS24665-300	COTTER PIN
	23	3	MS24665-151	COTTER PIN
	24	2	NAS1149C0432R	WASHER
-	25	6	NAS1149F0432P	WASHER
	i 26	8	NAS1149F0332P	WASHER
	127	4	NAS1149F0563P	WASHER

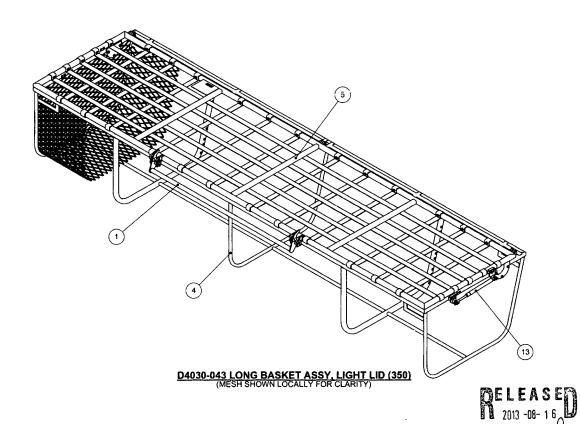


DESIGN AJS DART AFROSPACE LTD					
REV.		DE	SCRIPTION	BY	DATE
Α	NEW IS	SUE		JPH	10.03.16
В	AN5-21/	BOLT WAS ANS-	19A: BOM & (D3-3)	JPH	10.04.06
С	(B8-1): (	R ITEMS #30 & #3 DTY FOR ITEM #3 ED, AFFECTS SEC	1 UNDER -043 WERE MISSING WAS 4 (D6-1), ONLY 2 ARE CTION C-C (D3-3).	мв	10.07.23
Ð	MULTIP	LE VIEWS DUE TO	Y. PICTORIAL UPDATE TO CHANGES IN SUB ASSEMBLIES.	AJS	13.07.18

DESIGN	AJO	J DAKI AEKOSPACE LID I
DRAWN	AJŞ	HAWKESBURY, ONTARIO, CANADA
CHECKED	P	DRAWING NO. REV. D
MFG. APPR.	100	D4030 SHEET 1 OF 4
APPROVED	rus	TITLE SCALE
DE APPR.		LONG BASKET ASSY (350) NTS
DATE 13.0	7.18	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOOUNER IS TRIVIATE AND OUTDERTHE AND EMPLEO ON THE EMPERO DOMETION THAT IT IS NOT TO BE USED FOR ANY PROPOSE OR COMPANION THE OTHER PERSON WITHOUT.

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 72 lbs APPROX

ITEM	-043	P/N	DESCRIPTION
	Х	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	D2530	HANDLE WELDMENT
2	2	D2535	SPRING
3	2	D2537	BUSHING
4	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1	D3915-041	LIGHT LID ASSY, LONG BASKET
6	6	D3917-3	WASHER
7	2	D3953-3	GAS SPRING STUD, LID
8	2	D3953-7	GAS SPRING SPACER
9	2	D3953-9	GAS SPRING WASHER
10	2	D3953-17	GAS SPRING SPACER
11	1	D3953-19	GAS SPRING BRACKET
12	1	D3953-21	GAS SPRING BRACKET
13	1	D3969-3	SPRING
14 15	4	AN3-14A	BOLT
	2	AN3-20A	BOLT
16	3	AN4-12	BOLT
17	2.	AN5-17A	BOLT
18	2	AN5-21A	BOLT
19	3	AN310-4	NUT, PLAIN, CASTELLATED
20	2	AN310C4	NUT, PLAIN, CASTELLATED
21	6	MS21042L3	NUT, SELF-LOCKING
22	4	MS21042L5	NUT, SELF-LOCKING
23	3	MS24665-151	COTTER PIN
24	2	MS24665-300	COTTER PIN
25	6	NAS1149F0432P	WASHER
26	4	NAS1149F0563P	WASHER
27	8	NAS1149F0332P	WASHER
28	2	NAS1149C0432R	WASHER

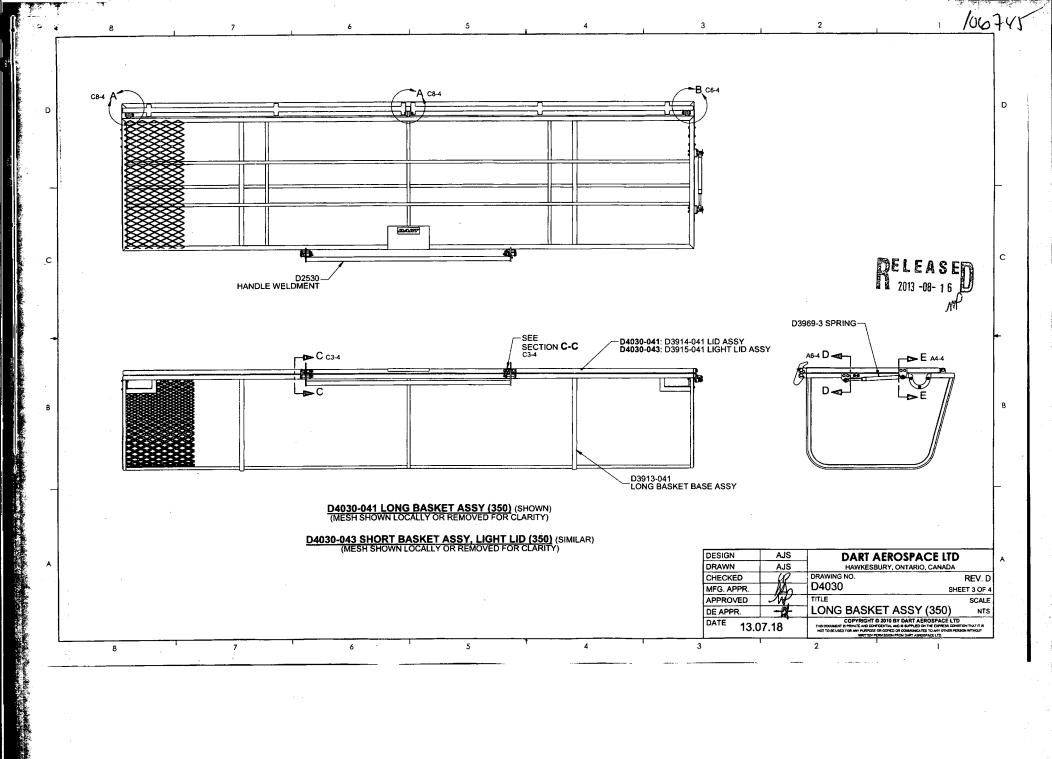


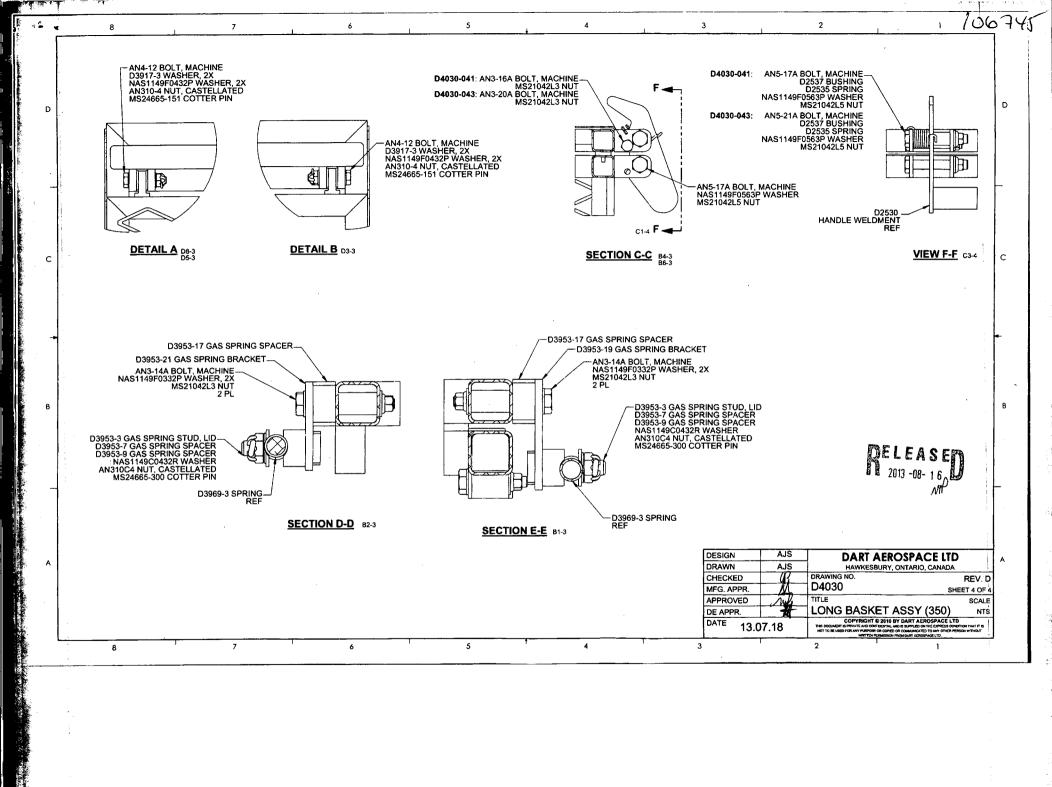
DESIGN AJS DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN AJS DRAWING NO. CHECKED REV. D D4030 MFG. APPR. SHEET 2 OF 4 TITLE APPROVED SCALE LONG BASKET ASSY (350)

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THIS DODUMUS IS BRING AND CORPUTA AND IS APPLED ON THE EXPRESS CORPUTA
HIS DUBBLISHED AND AND ARREST OF CORPUTA OF THE PROPERS AND THE PROPERS DE APPR. DATE 13.07.18

NOTES:
1) MATERIAL: N/A
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT: 57 lbs APPROX





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